

Work Order ID 52757

October 14, 2009 9:05:53 AM



Page 1

Item ID: D3953-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Stud, Lid

Start Date: 14/10/2009 Start Qty: 16.00



Cust Item ID:

Required Date: 21/10/2009 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 09-10-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3953

A

100

0.00



Doosan

Doosan Lathe

Memo

Turn as per folio FA852 & DWG
FOLIO REV: *2/1*
DWG REV: *A*

0.00

FA 09/10/16

20 *0*

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

FA 09/10/16

20 *0*

Work Order ID 52757

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Page 2

Item ID: D3953-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Stud, Lid

Start Date: 14/10/2009 Start Qty: 16.00



Cust Item ID:

Required Date: 21/10/2009 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	mf 09/10/16			20	0		
130 Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00	139B			9/10/19	200	50	
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00	09/10/19			mf 09-10-19			

Picklist Print

October 14, 2009 9:06:04 AM

Page 1

Work Order ID: 52757



Parent Item: D3953-3



Parent Item Name: Gas Spring Stud, Lid

Start Date: 14/10/2009

Required Date: 21/10/2009

Comments:

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304RO.750

Purchased

No

100

f

16.7300

2.1053



304 SS Roundbar .750

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

16.73

109421

1.39

110166

1.44

110912

6.06

111323

3.5

111988

4.34

2.524 8/10/16

DART AEROSPACE LTD		Work Order: 52757
Description: Gas Spring Stud Lid		Part Number: A3953-3
Inspection Dwg: A3953 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.75	±.030	Ø.750	/			
.56 typ.	±.030	.560	/			
.281 typ.	±.010	.281	/			
1/4-28 UNF-2A	N/A	1/4-28 UNF	/			
Major Ø	Max. .2490 Min. .2425	Ø.244	/			
M.O.W.	Max. .26687 Min. .26357	.2645	/			
Ø.098	+ .004 - .001	Ø.102	/			
Ø.250	±.010	Ø.242	/			
.170	±.010	.173	/			
.330	±.010	.330	/			
.13	±.030	.132	/			
R.06	±.030	R.06	/			
1.31	±.030	1.315	/			

Measured by: SA	Audited by: [Signature]	Prototype Approval: N/A
Date: 09/10/16	Date: 09/10/16	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SUPPLY

RETURN

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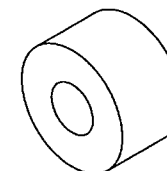
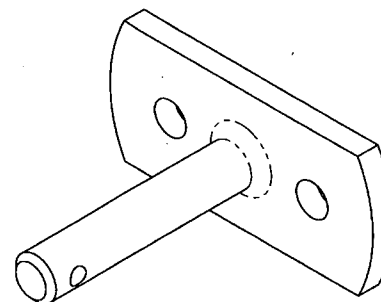
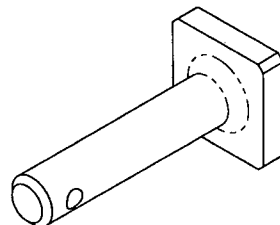
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WORK ORDER

NO. 52757

09-10-14



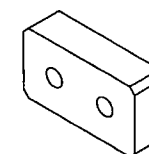
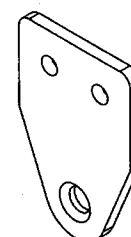
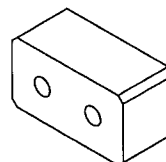
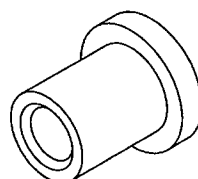
D3953-1 GAS SPRING BRACKET
(FULL LID)

D3953-3 GAS SPRING STUD, LID

D3953-5 GAS SPRING STUD, BASE

D3953-7 GAS SPRING SPACER

D3953-9 GAS SPRING WASHER



D3953-11 GAS SPRING SPACER

D3953-13 GAS SPRING SPACER
(FULL LID)

D3953-15 GAS SPRING BRACKET
(SPLIT LID)

D3953-17 GAS SPRING SPACER
(SPLIT LID)

RELEASED
2009-10-08

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3953 TITLE GAS SPRING LID COMPONENTS SCALE NTS	AJS	09.07.27
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MFG. APPR.				
APPROVED				
DE APPR.				
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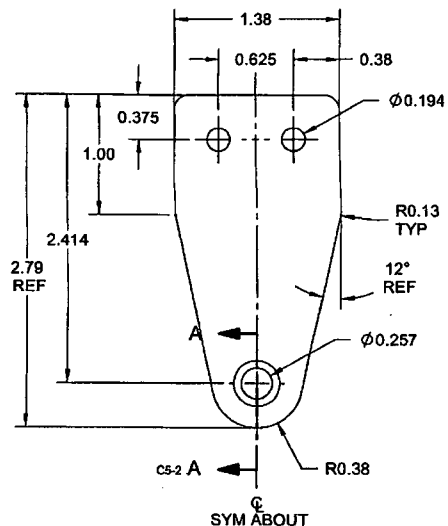
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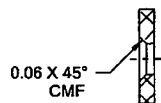
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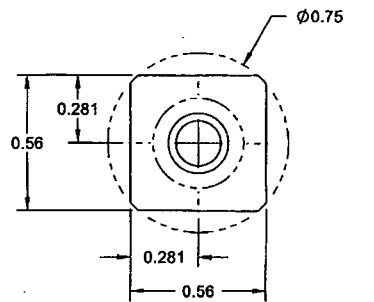
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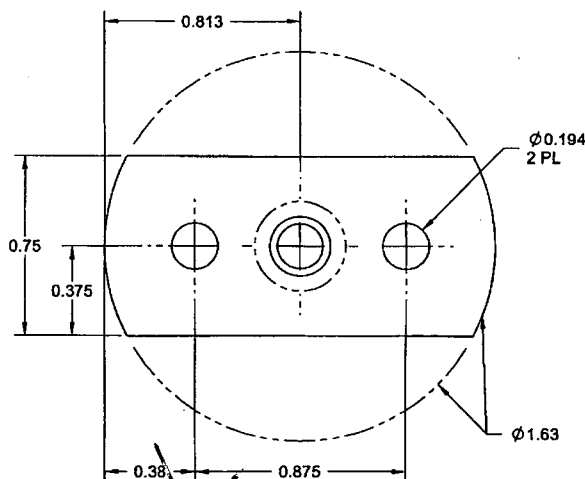
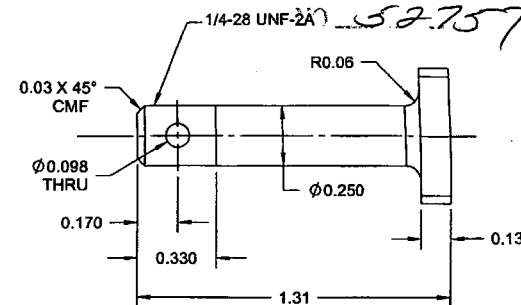
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(FULL LID)



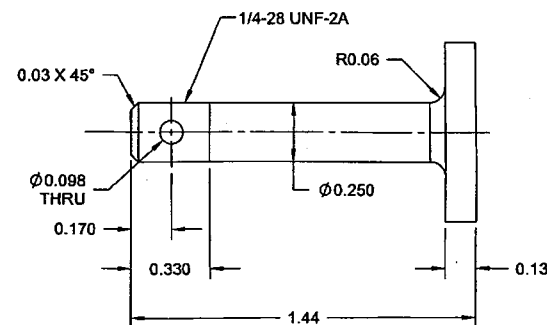
SECTION A-A C7-2



D3953-3 GAS SPRING STUD, LID



D3953-5 GAS SPRING STUD, BASE



NOTES:

1) MATERIAL -1: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
REF DART SPEC M304S

-3 & -5: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

OR: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -1: 0.11 lbs
-3: 0.03 lbs
-5: 0.06 lbs

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DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
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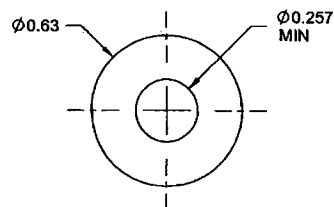
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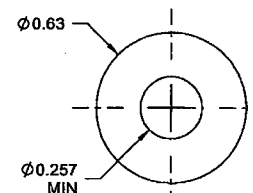
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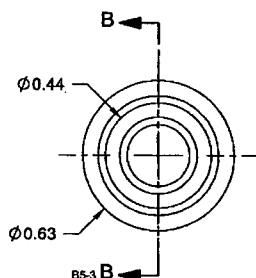
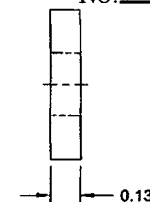
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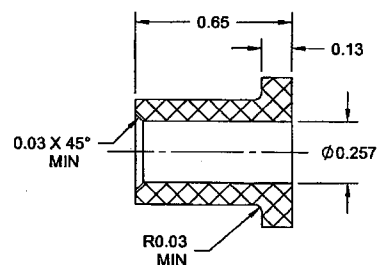
D3953-7 GAS SPRING SPACER



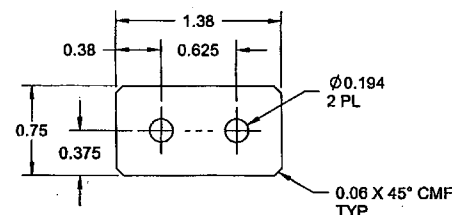
D3953-9 GAS SPRING WASHER



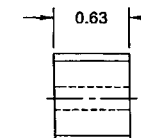
D3953-11 GAS SPRING SPACER



SECTION B-B B7-3



D3953-13 GAS SPRING SPACER



RELEASED
2009-10-08

NOTES:

1) MATERIAL -7, -9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

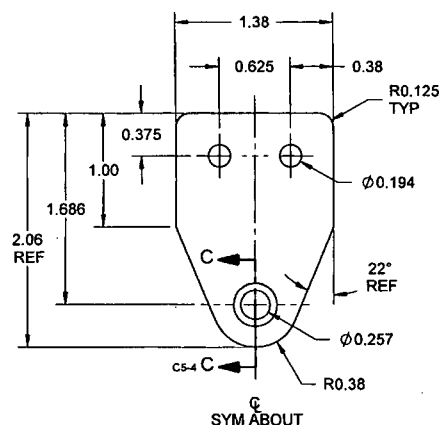
7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

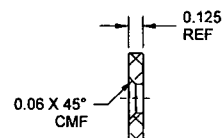
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MFG. APPR.	<i>[Signature]</i>	TITLE GAS SPRING LID COMPONENTS	SCALE NTS
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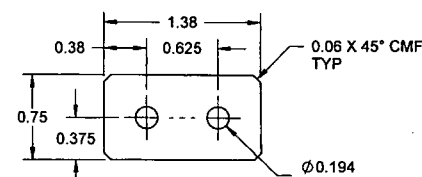
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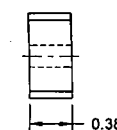
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



SECTION C-C C7-4



D3953-17 GAS SPRING SPACER
(SPLIT LID)



NOTES:

1) MATERIAL -15: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
REF DART SPEC M304S

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -15: 0.08 lbs
-17: 0.10 lbs

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2009 -10- 08
WHD

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